

Work Order ID 151699

Friday, October 07, 2016 2:33:08 PM

151699

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Item ID: D2530 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Handle Weldment
 Start Date: 9/28/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 10/7/2016 Req'd Qty: 4.00 ***4*** Customer:

Reference:

DAS
21

Approvals: Process Plan: 9-20 Date: OCT 12 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2530	Rev B ✓

100	Small Fab	0.00							
100									
Small Fab	Memo	0.14							
Small Fab	1-Cut to length as per Dwg D2536 2-Deburr								

4 FB DEC 01 2016

110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									

QC5
work order update
DAS
9-89

④ 16-12-01 DAS 9 9-89
P70

120	Weld per dwg A/R S.S. rod Batch: <u>134992</u>	0.00							
120									
Large Fab	Memo	0.13							
Large Fab	1-Weld as per Dwg D2530 and QSI 004 using Welding Jig DT8301								

4 16-12-07 JOL

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
130									DAS
QC	Memo	0.00				④	16-12-07		9 9-89
Quality Control									
140	QC5- Inspect part completeness to step on W/O	0.00							
140									DAS
QC	Memo	0.01				④	16-12-07		9 9-89
Quality Control									
150	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.01							
Powder Coating	START TIME: 1:35 OVEN TEMPERATURE: 320° FINISH TIME: 2:05								
						4	16-12-08		33 9-89

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						4			DAS 38 9-89
QC	Memo	0.01							
Quality Control									DEC 09 2016
170	Identify as per dwg & Stock Location: <u>Stg 9</u>	0.00							
170						4			DAS 6 9-89
Packaging	Memo	0.01							DEC 12 2016
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									16/12/13
QC	Memo	0.07							
Quality Control									

16-12-12

Picklist Print

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Parent Item: D2530

D2530

Parent Item Name: Handle Weldment

Start Date: 9/28/2016

Required Date: 10/7/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E Removed Purchasing 05-11-07 JLM IPP Rev:F
11.01.07 chg qc 5 to 6 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2534		Manufactured	No			120	Each	67.0000	2	8			

D2534

Lock Plate

16-12-07
/m

Location	Loc Qty	Loc Code
WA004	67	
139017	1	
145921	36	
147543	20	
149123	10	

M304TR0.750W.049

Purchased

No

100

f

235.1431

2.9145

12.27158

FF DEC 0 1 2016

M304TR0 750W 049

304 RD Tube .750 x .049W

Location	Loc Qty	Loc Code
GA002	235.143056	
M134306	2.75	
M134528	30.2105266	
3x M134604	43.420524	
M134824	7.618947	
1x M135093	33.68421	
M135242	42.4210615	
M135325	0.6571554	
M135373	60.2332615	
M135709	14.14737	

9.203685
3.067895

INSPECTION SHEET

DAS
30
9-89

~~DEC 01 2016~~

Date:

Revised by
KJ